

Date: Wednesday, 13/08/2008 9:52:51 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D407-667-205
Job Number : 41197	
Estimate Number : 10804	
P.O. Number :	Part Number : D407667205
This Issue : 13/08/2008 S.O. No. :	Drawing Number : ECN1225 - REWORK
Prsht Rev. : NC	Project Number :
First Issue : 13/08/2008 Type : CROSSTUBES	Drawing Revision :
Previous Run : 41182	Material :
Written By :	Due Date : 22/08/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

PULL FROM STOCK:

1 X D407-667-205 B39428

ml 08 08 13

①

2.0

D407667205

Crosstube Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Aft

ml 08 08 13 ①

3.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1
 REWORK TUBE PER ECN1225
 MOVE BOTH CHAFING SHIELDS 0.375"
 TOWARD CL 0.0.

ml 08 08 13

①

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

080813 ①

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT FOR ORIGINAL KIT
 TO BE INCLUDED

080814 ①

Date: Wednesday, 13/08/2008 9:52:51 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 41197

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



②

Comment: PACKAGING RESOURCE #1
REPACKAGE USING NEW B/N
@ CHG 006
NEW LABELS REQ'D

LOC 53

Rev D

8/8/14

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

12/08/2015

Job Completion



608-08-15

IS 41197 D407-667-205

DART DART Aerospace Ltd. 12700 BERDEEN ST. HAWKESBURY ON, CANADA K6H 1K7		TC APPROVAL #09-89 TEL: 513-632-6200	
P/N	D407-667-205	CHG	CHG004
DESC.	Crosstube Air High	SH	SH01-5
LOT	B39428	SR	SR01304NY
MODEL	Bell 407	SIC	
MADE IN CANADA		02729-1	

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 08.07.17	Job No.:	ADR Yes/No: <input checked="" type="checkbox"/> Y	ADR Date: 08.07.17	ECN #: 1225
Product No.: D407-667-245		Created By: <i>[Signature]</i>	Approved By: <i>[Signature]</i>	
Product Name: CROSSTUBE ASSY (407 HIGH AFT)		Checked By: <i>[Signature]</i>	General Manager Approval:	

Distribution	Reqd	Resp	Received
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	
Director Quality Assurance	N		
Customer Order Processing	N		

Distribution	Reqd	Resp	Received
Customer Technical Support	Y	DS	
Marketing	N		

Reason for Change:
REVISED SUPPORT LOCATION ON CROSSTUBE: MOVED EACH SUPPORT 3/8" TOWARD BL0.0 (CROSSTUBE'S CENTERLINE) PER CAR#08-21

Documents Affected:
RELEASE D407-667-245 REV. E

#	Engineering Actions	Reqd	Resp	Notes	Complete
1	Required Documents/Drawings Under Review	Y	CP		<i>[Signature]</i> 08.02.17
2	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		
3	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		
4	Update Grey Project Binder	Y	KJ	ADR	
5	Move Electronic Files	Y	KJ		
6	Update Master Document List (MDL)	Y	MB		<i>[Signature]</i> 08.06.07
7	Update Document Record (DR)	Y	KJ		
8	Create/Update Change Record Form	Y	KJ	-205 NOW @ CHG 006 AND -205A @ CHG 004	
9	Create/Update PPP's	Y	KJ	AS REQUIRED	
10	Update Controlled PDF Files	Y	KJ		
11	Notify TC/FAA of Change	N			
12	Update QSI 021 and/or STC Approval List	N			
13	Update Product Development Summary	N			
14	Update Accpac Database	N			
15	Update Access (ARC) Database	N			
16	Update/Verify ARC	N			
17	Update Paperwork Kits in Production	Y	KJ	AS REQUIRED	<i>[Signature]</i> 4/1/97
18	Update Qpulse/Laminated Dwgs	N			
19	Update Product Compatability Matrix	N			
20	Create Eurocopter Form (FEE)	N			
21					

#	Production Actions	Reqd	Resp	Notes	Complete
22	Create/Update Coss IPP/BOM	Y	EC/DD	AS REQUIRED + SEE BELOW	
23	Update FAI Sheets	Y	EC/DD	AS REQUIRED + SEE BELOW	
24	Create/Update CNC Programs	N			
25	Create/Update Tooling	Y	EC/DD	AS REQUIRED + SEE BELOW	
26	Red Tag Stock (Specify)	Y	JM	PER CAR#08-21	
27	Rework/Scrap Current Production and/or Stock	Y	LL	REWORK AS REQUIRED.	
28	Update Paperwork Kits in Stock	N			
29	Create/Update MPP	Y	EC/DD	AS REQUIRED	
30					

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
31	Notify Previous Customers	N			
32	Notify Eurocopter France	N			
33					

Description / Action:
TAKE NOTE THAT THE DWG HAS CHANGED CONSIDERABLY TO REFLECT THE LATEST DART'S DWG STDS.
REVIEW ANY OF THE PRODUCTION'S DOCUMENTS REFERING TO SPECIFIC VIEWS OR CALLOUTS.
VERIFY NEW LOCATION OF SUPPORTS PRIOR REMOVING THE ABRASION STRIPS. RELOCATE ABRASION STRIPS ONLY IF NECESSARY.

AMENDMENT DESIGN REVIEW (ADR)Part/Installation No.: D407-667-245 Rev: E Design Review No.: _____ Date: 08.07.31Project Number: 00056 Project Description/Title: CROSSTUBEEng. Project Manager: M. BELLAVANCE ASSY (407 HIGH AFT)

Persons Present	Title	Initial
MIKE PETSCHÉ	Design Manager	<i>MP</i>
M. BELLAVANCE	Engineering Project Manager	<i>MB</i>
D. SHEPHERD	Chief Engineer (DE #02)	<i>DS</i>
	Manufacturing Manager	
	Quality Manager	
J. MURDOCH	Q.C. Inspector	<i>JM</i>

Comments

GENE LEBLANC, AIR LOGISTIC'S INSPECTOR, REPORTED THAT THE INNER MOST CLAMPS FASTENING THE CHAFFING SHIELDS INTERFERE WITH THE AIRCRAFT'S ROCKER BEAM MOUNTS (REF. PAR#08-21).

IT WAS DETERMINED THAT THIS INTERFERENCE CAN BE ELIMINATED BY MOVING BOTH CHAFFING SHIELDS 0.375" TOWARD BL 0.0.

THIS IS A MINOR DIMENSIONAL CHANGE AND APPROVAL BY DE#02 IS ACCEPTABLE.

41182
41195

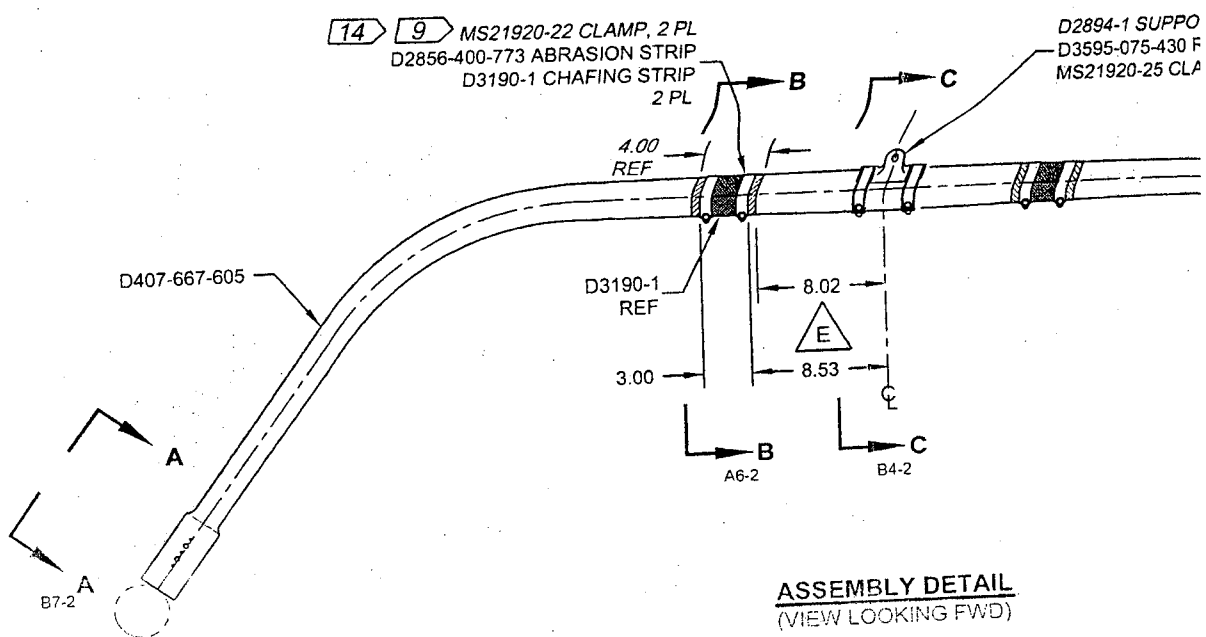
Key Tasks (Check or N/A)	Check	Responsible	Completion Date
Review Outstanding TSR/NCR/CAR/PAR	Y	MP	
Fill out Criteria/Constraints Form – Inputs	N/A		
Fill out Project Evaluation Form	N/A		
D-Part creation/revision	Y	MB	
Get Manufacturing Input	N/A		
First Article Inspection	N/A		
Fit and Function Test	N/A		
Structural Test	N/A		
Reports (Compliance, Loads, Stress, Conformity, DSI)	N/A		
Check Drawings against all QSIs	Y	MB	
Review Criteria/Constraints Form	N/A		
Revision to existing approval	N/A		
Close Amendment Project	Y	MB	

Conclusion:

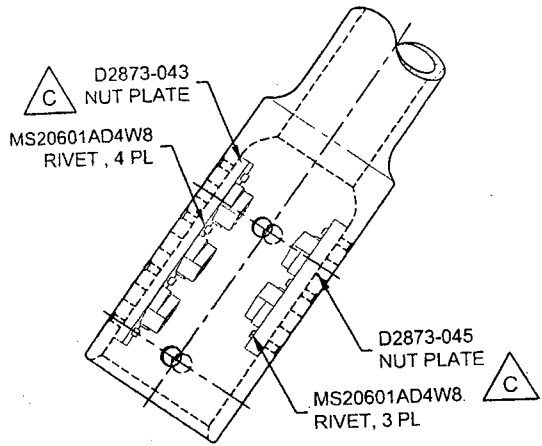
PROCEED WITH THE REVISION OF DRAWING D407-667-245 FROM REV. D TO REV. E AND RELEASE THROUGH ECN#1225.

RELEASED
08-08-11/11

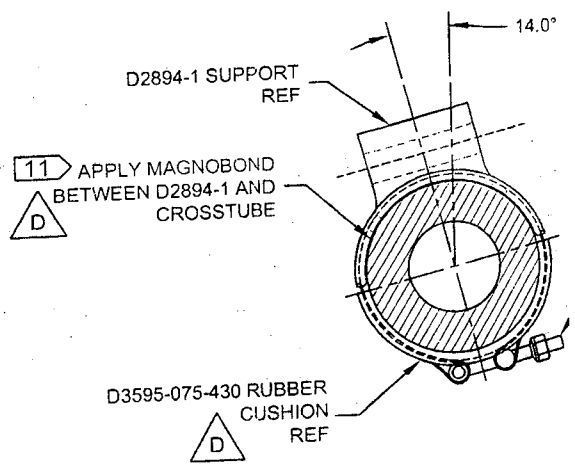
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D407-667-245	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.07.24	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



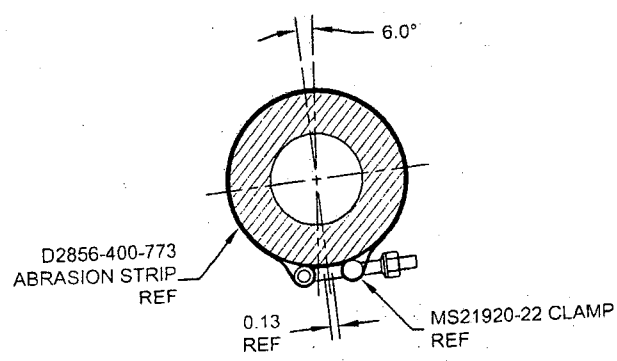
ASSEMBLY DETAIL
(VIEW LOOKING FWD)



VIEW A-A CUFF DETAIL
SCALE 4X

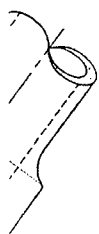
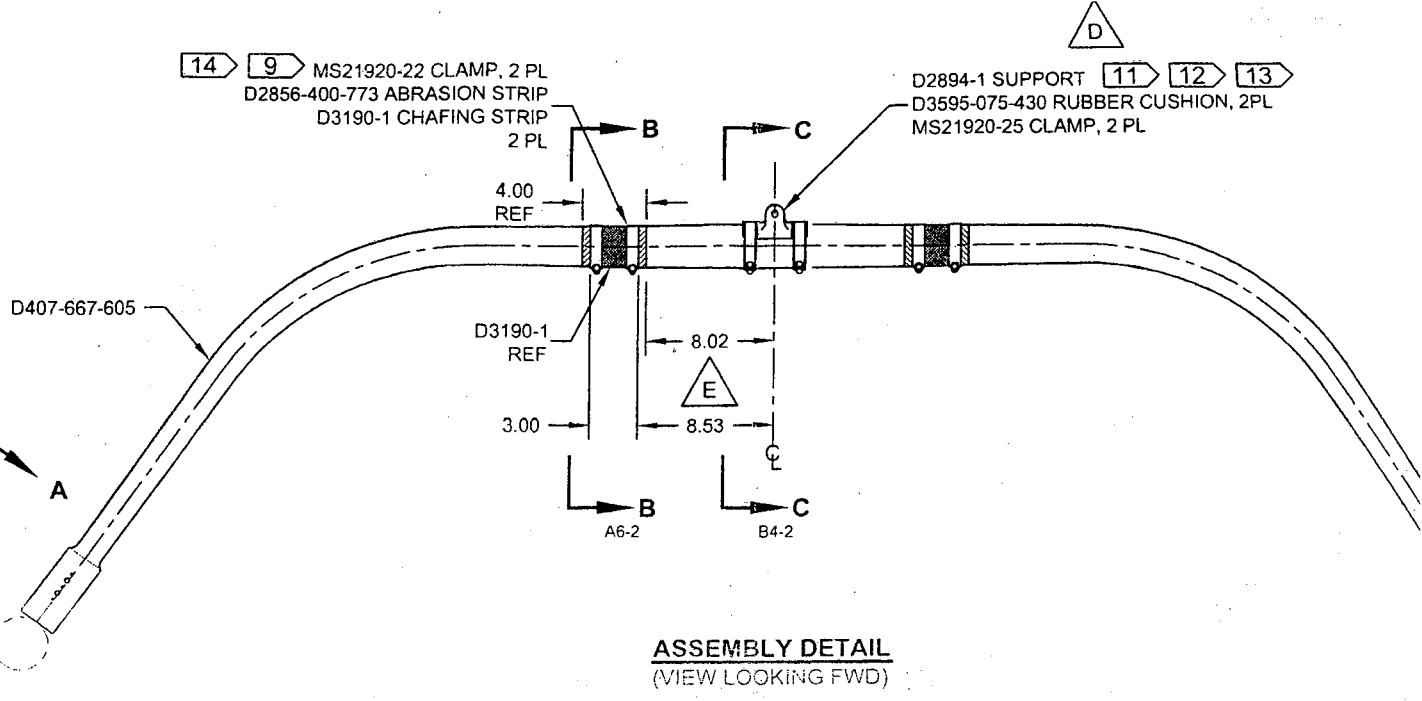


SECTION C-C
SCALE 4X



SECTION B-B
SCALE 4X, 2PL

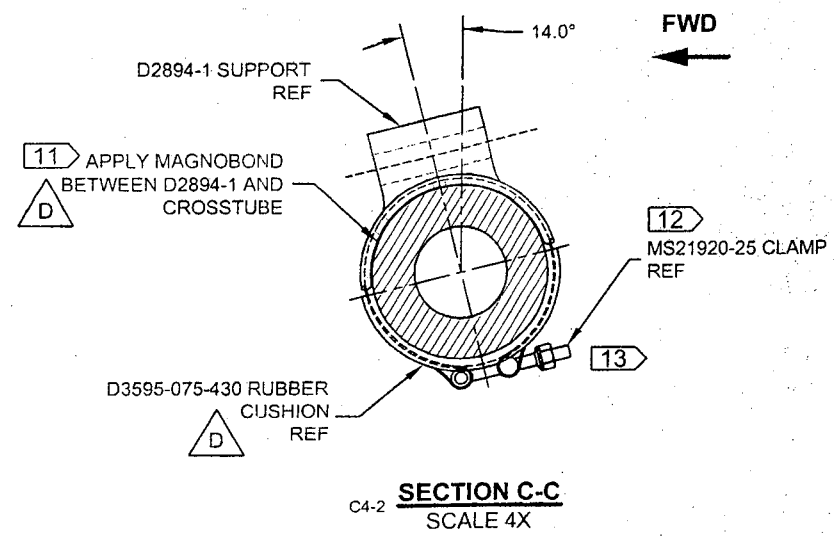
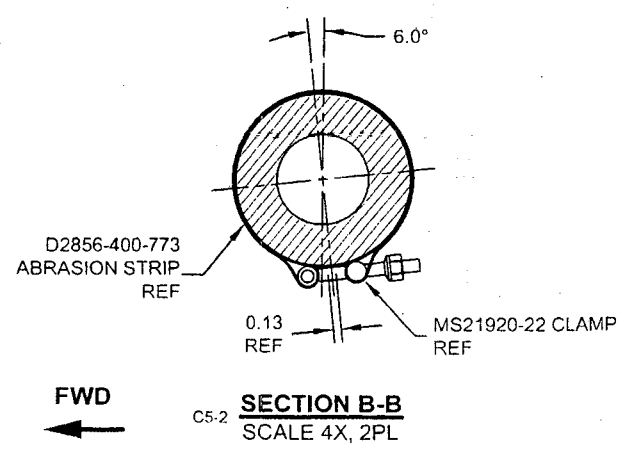
FWD
←



D2873-045
NUT PLATE
301AD4W8
3 PL

C

CUFF DETAIL
SCALE 4X



DESIGN
DRAWN
CHECKED
MFG. AP
APPROV
DE APPF
DATE

34

Date: Wednesday, 13/08/2008 9:52:51 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D407-667-205
Job Number : 41197	
Estimate Number : 10804	
P.O. Number :	Part Number : D407667205
This Issue : 13/08/2008 S.O. No. :	Drawing Number : ECN1225 - REWORK
Prsht Rev. : NC	Project Number :
First Issue : 13/08/2008 Type : CROSSTUBES	Drawing Revision :
Previous Run : 41182	Material :
Written By :	Due Date : 22/08/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	CROSSTUBES	CROSSTUBES RESOURCE 1
-----	------------	-----------------------



Comment: CROSSTUBES RESOURCE 1

PULL FROM STOCK:

1 X D407-667-205 B39428

2.0	D407667205	Crosstube Aft
-----	------------	---------------

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Crosstube Aft

3.0	CROSSTUBES	CROSSTUBES RESOURCE 1
-----	------------	-----------------------

Comment: CROSSTUBES RESOURCE 1
REWORK TUBE PER ECN1225
MOVE BOTH CHAFING SHIELDS 0.375"
TOWARD BL 0.0.

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------

Comment: INSPECT FOR ORIGINAL KIT
TO BE INCLUDED

Date: Wednesday, 13/08/2008 9:52:51 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 41197

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE USING NEW B/N
@ CHG 006
NEW LABELS REQ'D

720088-14

2

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

